

# Work Order ID 78592

**\*78592\***

January-11-12 2:42:43 PM

Page 1

Item ID: D3537-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad  
 Start Date: 11/01/2012 Start Qty: 40.00 **\*40\*** Cust Item ID:  
 Required Date: 25/01/2012 Req'd Qty: 40.00 **\*40\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	Rev C								

100 0.00  
**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00 B12-1-31  
 FLOW CNC Waterjet 1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr  
 304.063 if necessary

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00 B12-1-31  
 Quality Control

120 0.00  
**\*120\*** QC8- Inspect parts - second check  
 QC Memo 0.00 counts  
 Quality Control 68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
<b>*130*</b>									
Brake NC	Memo	0.00							
Brake NC	1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.2- Identify as D3537-1								
140	Large Fab	0.00							
<b>*140*</b>									
Large Fab	Memo	0.00							
Large Fab	Qty: Description Batch A/R 2059B Hardcoat 1-Weld as per Dwg D3537 using Jig DT 82102-Remove any weld that penetrated through Wearpad if necessary								
150	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

68

SB 12/02/01

768 JBL 12-02-16

Size 1/4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

170	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<b>*170*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>8:30</u> OVEN TEMPERATURE: <u>9:00</u>								

180	QC3- Inspect Part Finish	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

Handwritten notes: 68x d m 12/02/17  
68x d m 12/02/17  
 counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 25/01/2012      Req'd Qty: 40.00      **\*40\***      Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>F-P 2</u>	0.00							
<b>*190*</b>									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									

68X4 M / 12/02/17

12/2/17

MF  
12-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 78592

**\*78592\***

Parent Item: D3537-1

**\*D3537-1\***

Parent Item Name: Wearpad

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

99.3300

0.106

4.463158

2.5

**\*M304S16GA\***

**\*\***

IB 12-1-31

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

99.33

119346

31.5

119653

67.83

119653

68

W/O:		WORK ORDER CHANGES					
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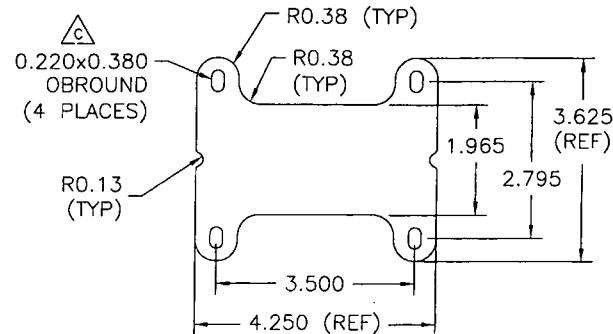
SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED  
SUBJECT TO AMEND

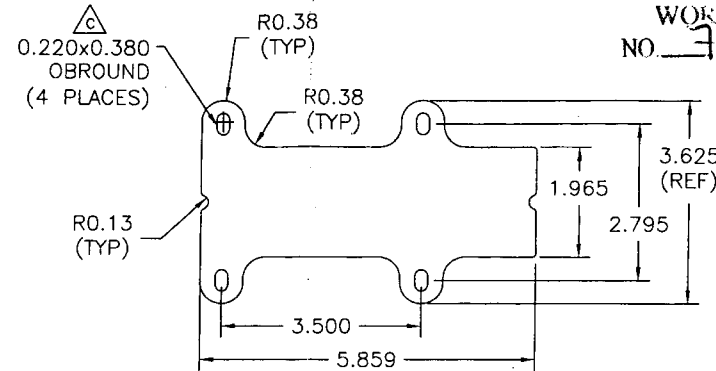
WITHOUT NO  
WORK OR!

NO. 38592 M.L.S.  
12/01/11

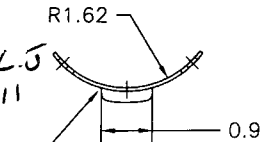
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN



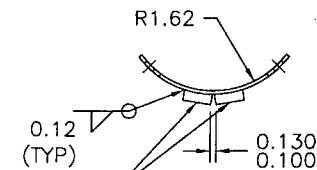
### SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

OK 11/11/11

### SECTION B-B

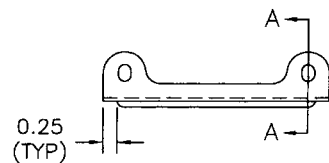


D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

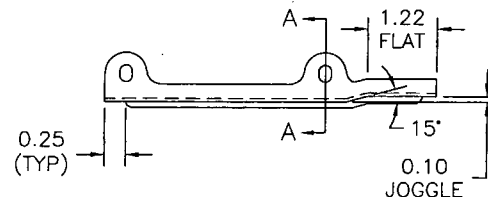
UNDER REVIEW  
11/11/11  
per ECLN  
962

**RELEASED**  
07.05.08 Ad  
per ECLN  
962

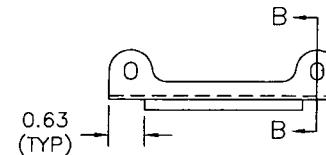
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



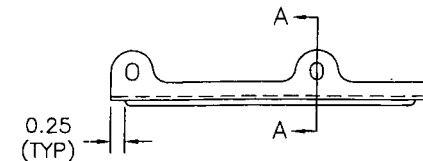
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

DESIGN	C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
CHECKED	B	07.03.20	ADD AMS 5513 AND AMS 5524
DATE	A	06.11.06	NEW ISSUE
DRAWN BY	CB	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, VA
APPROVED	#	#	DRAWING NO. D3537
TITLE			WEARPAD
REV. C			SHEET 1 OF 1
SCALE			1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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